

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008827**Date Inspected:** 07-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia, Li Hong Fei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT-2AW-2BW

FCAW welding process of weld joint 174 located on PCMK SSD40A-PP14. Welder is identified as 220063ZPMC QC is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

BAY#11

This QA Inspector randomly observed the following work in progress.

SAW welding process of weld joint 1A located on PCMK WD1-A6003-8. Welder is identified as 044550 ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-B-T-4221-B-U3C-S-1.

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FCAW welding process of weld joint 1A/B located on WSD1-SPSA4-53. Welder is identified as 040775ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

BAY#14

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 125 located on PCMK SSD14-PP79. Welder is identified as 202122 ZPMC QC is identified as Li Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

FCAW welding process of weld joint 129 located on PCMK SSD14-PP79. Welder is identified as 201215 ZPMC QC is identified as Li Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

FCAW welding process of weld joint 93 located on PCMK DP453-001. Welder is identified as 048038 ZPMC QC is identified as Li Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

SMAW welding process of weld joint 030 located on PCMK SP632-001. Welder is identified as 054013 ZPMC QC is identified as Li Jie. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

FCAW welding process of weld joint 131 located on PCMK SSD19A-PP91. Welder is identified as 055491 ZPMC QC is identified as Li Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
